

Date: Monday, 4/23/2007 1:53:58 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 407 UTILITY BASKET
Job Number	: 31999		
Estimate Number	: 10920		
P.O. Number	: <i>N/A</i>	Part Number	: D407663011
This Issue	: 4/23/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2955 REV B
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 29857	Drawing Revision	: B
		Material	: <i>N/A</i>
		Due Date	: 5/15/2007
Written By	:	Qty:	1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev: F 05.10.19 Added D2728-3 & AN960JD416L KJ/JL M		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D407-663-011CHG002

KS 07.08.07 (1)

2.0	31999A	407 BASKET BASE ASSEMBLY
-----	--------	--------------------------



Comment: Sub-Component 407 BASKET BASE ASSEMBLY

D2948-041 B *31999 A*

ml 07/06/08

3.0	31999B	407 BASKET LID
-----	--------	----------------



Comment: Sub-Component 407 BASKET LID

D2952-041 B *31999 B*

ml 07/06/08

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

5.0	D2332041	Lid Prop Assembly 6.69"
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Assembly Kit

7

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2332-041	Prop Ass	<i>1531694 - 2</i>
---	-----------	----------	--------------------

[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:53:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 UTILITY BASKET

Job Number: 31999

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment B31106

7.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535 Spring B31486

8.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537 Bushing B31107

9.0

D27283

Dart Logo label large



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2728-3 Label B22553

10.0

D2851145

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 d2851-145 Placard B32019

11.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2931 Bumper B21139

[Signature]
B31106/270

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:53:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 UTILITY BASKET

Job Number: 31999

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2961

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D22961

Label

512077

13.0

AN320A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-20A

Bolt

M15432

14.0

AN414A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-14A

Bolt

M102473

15.0

AN422A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-22A

Bolt

M104214

16.0

AN517A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN5-17A

Bolt

M104016

17.0

AN521A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN5-21A

Bolt

M16463

[Signature]
Form: process

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:53:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 UTILITY BASKET

Job Number: 31999

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD416 Washer M103691

19.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD416L Washer M103691 M104214

20.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516 Washer M103694

21.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD8 Washer M104156

22.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer M103344

23.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

M102929

EPB/66/270

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:53:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 UTILITY BASKET

Job Number: 31999

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 MS20600AD4W3 Rivet

24.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) 1103691

25.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4) 1102552

26.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L5 Nut (or -5) 1103446

27.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble basket as per Dwg D2955. Inspect for foreign objects as per QSI 024.

EP 04/06/270
ml 07/06/28
x1

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/06/28 *(41)*

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:53:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 UTILITY BASKET

Job Number: 31999

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

D2852

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

.Qty Part Number

Description Batch

1 D2852

Label

B30108 ✓ ✓

31.0

D2984

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

.Qty Part Number

Description Batch

1 D2984

Label

B12605 ✓ ✓

32.0

D407301011

Center Bracket Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

.Qty Part Number

Description Batch

1 D407-301-011 Center Bracket Kit

B29880 ✓ ✓

33.0

D407302011

Outboard Bracket Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

.Qty Part Number

Description Batch

1 D407-302-011 Outboard Bracket Kit

B29881 ✓ ✓

34.0

AN311A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

.Qty Part Number

Description Batch

6 AN3-11A

Bolt

M14820 ✓ ✓

35.0

AN960JD10

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

.Qty Part Number

Description Batch

6 AN960JD10

Washer

M104118 ✓

EP04/06/270

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/28

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:53:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 UTILITY BASKET

Job Number: 31999

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

MS21042L3

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

.Qty Part Number

Description Batch

6 MS21042L3

Nut (or -3)

M103691

Handwritten signature and date: 4/26/27

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Handwritten date: 4/27/07

Handwritten date: 4/27/07

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D407-663-011

Location:

PPP Rev:

Handwritten signature and date: 4/28/07

Handwritten circled 'C'

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten date: 4/28/07

Job Completion



Handwritten date: 4/28/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RF	APPROVED RF	DRAWING NO. D2955	REV. B SHEET 1 OF 2
DATE 00.07.17		TITLE BASKET ASSEMBLY SCALE NTS	
A	00.01.13	NEW ISSUE	
B	00.07.17	UPDATE TOP VIEW OF BASKET	

Qty -041	Part Number	Description
X	D2955-041	BASKET ASSEMBLY
1	D2332-041	LID PROP ASSEMBLY
1	D2530	HANDLE WELDMENT
2	D2535	SPRING
2	D2537	BUSHING
1	D2851-145	PLACARD
1	D2961	PLACARD
2 X	D2931	BUMPER
1	D2948-041	BASKET BASE ASSEMBLY
1	D2952-041	BASKET LID ASSEMBLY
2	AN3-20A	BOLT
2	AN4-14A	BOLT
2	AN4-22A	BOLT
2	AN5-17A	BOLT
2	AN5-21A	BOLT
6	AN960JD416	WASHER
4	AN960JD516	WASHER
2 X	AN960JD8	WASHER
4	AN970-4	WASHER
2 X	MS20600AD4W3	RIVET
2	MS21042L3	NUT (OR MS21042-3)
4	MS21042L4	NUT (OR MS21042-4)
4	MS21042L5	NUT (OR MS21042-5)

#00.09.08
RF

#00.09.08
RF

#00.09.08
RF

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31999

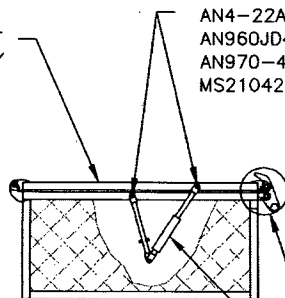
RELEASED
00.07.18

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

D2952-041 BASKET
LID ASSEMBLY

AN4-22A BOLT (1)
AN960JD416 WASHER (1)
AN970-4 WASHER (2)
MS21042L4 NUT (1)

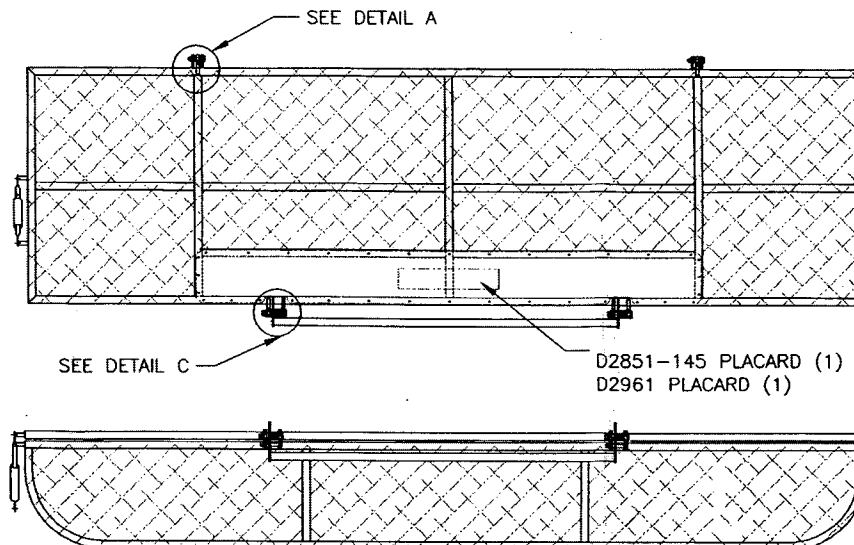


SEE DETAIL B

D2948-041 BASKET
BASE ASSEMBLY

PROP ARM DETAIL

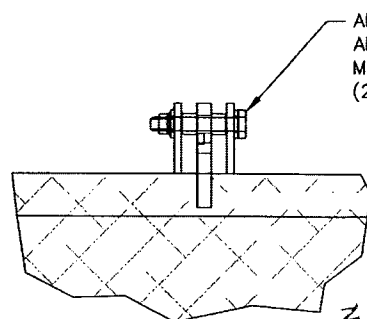
D2332-041 LID
PROP ASSEMBLY



D2955-041 BASKET ASSEMBLY

D2851-145 PLACARD (1)
D2961 PLACARD (1)

SEE DETAIL C



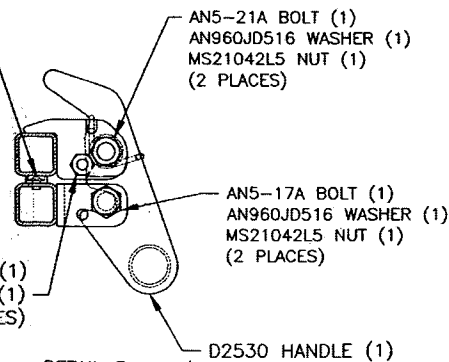
DETAIL A
HINGE DETAIL

NO. 21999
WORK ORDER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
RETURN TO
ENGINEERING
SHOP COPY

D2931 BUMPER (1)
MS20600AD4W3 (1)
AN960JD8 WASHER (1)
(2 PLACES)

2
RF
00.07.08

AN3-20A BOLT (1)
MS21042L3 NUT (1)
(2 PLACES)

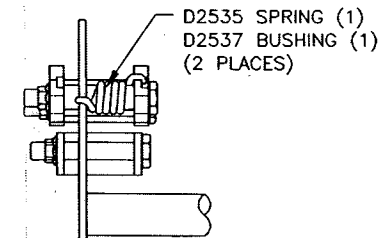


DETAIL B
LATCH DETAIL

AN5-21A BOLT (1)
AN960JD516 WASHER (1)
MS21042L5 NUT (1)
(2 PLACES)

AN5-17A BOLT (1)
AN960JD516 WASHER (1)
MS21042L5 NUT (1)
(2 PLACES)

D2530 HANDLE (1)



DETAIL C
SPRING DETAIL

D2535 SPRING (1)
D2537 BUSHING (1)
(2 PLACES)

RELEASED
00.07.18

COPYRIGHT © 2000 BY DART AEROSPACE LTD.		DESIGN RF	DRAWN BY RF	DART	DART AEROSPACE LTD. HAMMERSBURY, ONTARIO, CANADA
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED RF	APPROVED RF	DRAWING NO. D2955	REV. B SHEET 2 OF 2
DATE 00.07.17		TITLE BASKET ASSEMBLY		SCALE NTS	

Date: Monday, 4/23/2007 1:54:30 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 407 BASKET LID
Job Number	: 31999B		
Estimate Number	: 10917		
P.O. Number	: <i>N/A</i>	Part Number	: D2952041
This Issue	: 4/23/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2952 REV B
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 29857B	Drawing Revision	: B
		Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 5/15/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	1 Um: Each
Comment	: Est Rev: C 03.11.26 Reformat KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6TS0750W062	6061-T6 SQ Tube.75x.062W
-----	-------------------	--------------------------



Comment: Qty.: 39.3750 f(s)/Unit Total : 39.3750 f(s)
 Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 0.062" wall
 (M6061T6TS0.750W.062)
 Batch: *M104422*

FC 07/06/20

2.0	M5052H32S080	5052-H32 .080 Sheet
-----	--------------	---------------------



Comment: Qty.: 0.0656 sf(s)/Unit Total : 0.0656 sf(s)
 Material: 5052-H32/H34 (QQ-A-250/11 or QQ-A-250/8) 0.080"
 (M5052H32S.080) or M6061T6S080 (M6061T6S080)
 Batch: *M102723*
 Identify as D2952-11

M 07/06/21

3.0	D2953077	Spacer
-----	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 2 D2953-077 Spacer *B22095*

M 07/06/21

4.0	D2953175	Spacer
-----	----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 1 D2953-175 Spacer *B22096*

M 07/06/21

NO:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:54:30 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 BASKET LID

Job Number: 31999B

Part Number: D2952041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2957

Mounting Plate



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

6 D2957 Mounting Plate 2X B21198
4X B29869

107/06/21

6.0

M1100H14ES34X051F

Alum Expanded Metal



Comment: Qty.: 15.7500 sf(s)/Unit Total : 15.7500 sf(s)

Pick:

Qty Part Number Description Batch

15sf M1100H14ES-3/4x.051F Mesh M103088

107/06/26

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2952-11 corner gussets as per Dwg D2952

2-Drill holes in D2952-3 as per Dwg D2952.

3- Deburr & Remove any Markings From Material

4-Weld as per Dwg D2952 as per QSI 004. Deburr as required

A/R AL ROD Batch: M103794

107/06/26

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

107-06-26

9.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

107-06-26

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

107/06/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/04/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:54:31 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 BASKET LID

Job Number: 31999B

Part Number: D2952041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2983

Label Plate



B32023



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Label Plate

07/06/26

12.0

MS20600AD4W2

Rivet



Comment: Qty.: 34.0000 Each(s)/Unit Total: 34.0000 Each(s)
Rivet

M4747

07/06/26

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07-06-26 (1)

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble Label Plate as per Dwg D2952

07/06/26

15.0

POWDER COATING

POWDER COATING



M 104 144



①

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR/M/07-06-28

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m/07/06/28

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: GA

m/07/06/28

18.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

07/06/28

Job Completion



u 07/06/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

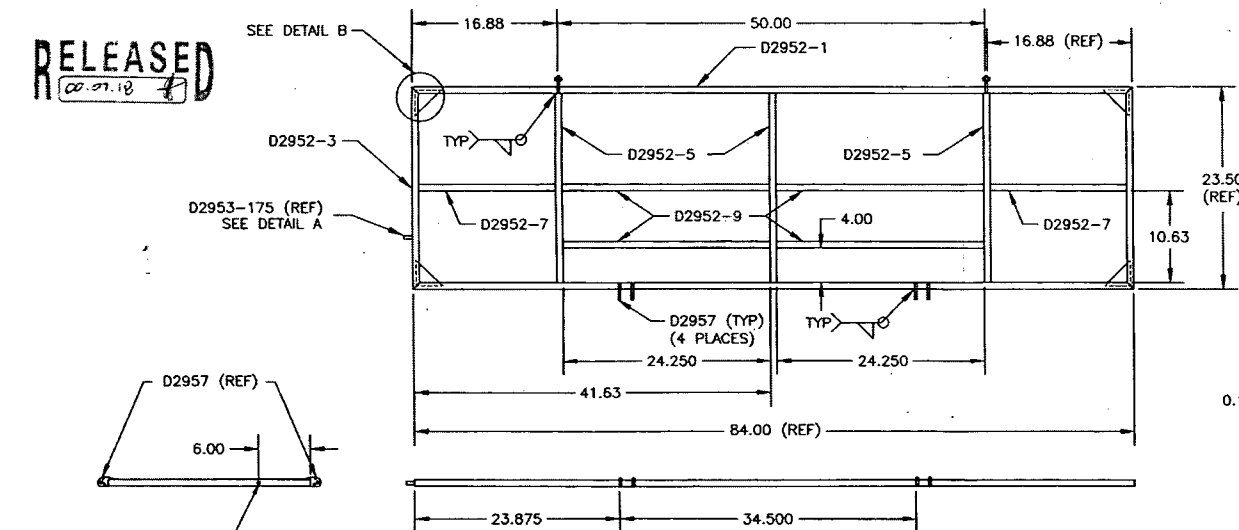
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

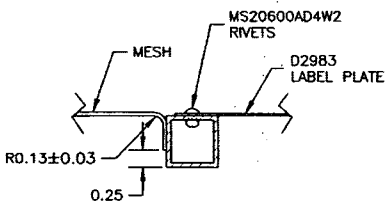
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

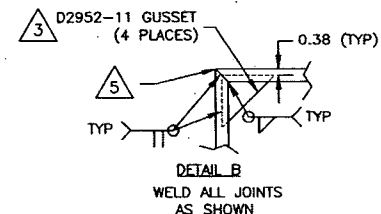
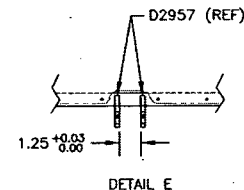
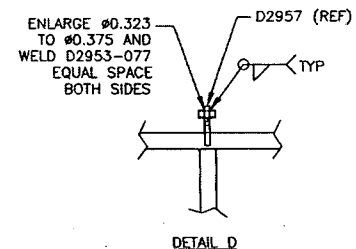
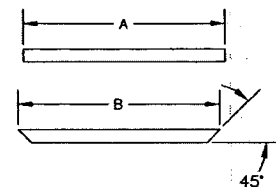
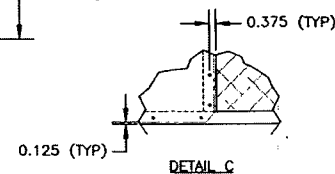
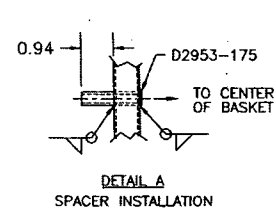
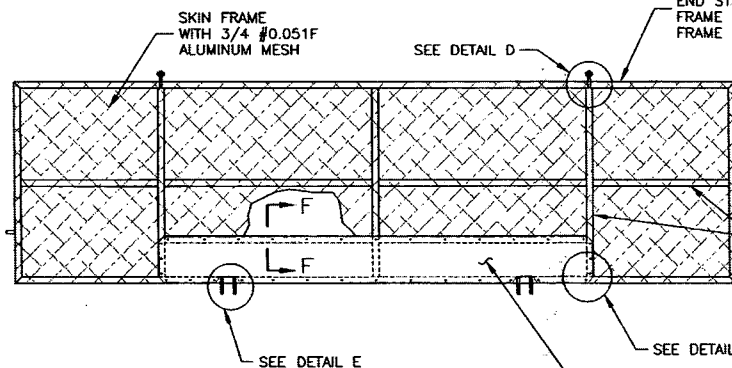
RELEASED
00.07.10



DRILL $\phi 0.375$ HOLE
AND INSTALL D2953-175
SEE DETAIL A



SECTION F-F



QTY	PART NUMBER	DESCRIPTION	LENGTH A	LENGTH B
X	D2952-041	BASKET LID ASSEMBLY	N/A	N/A
2	D2952-1	FRAME MEMBER	N/A	84.00
2	D2952-3	FRAME MEMBER	N/A	23.50
3	D2952-5	FRAME MEMBER	22.00	N/A
2	D2952-7	FRAME MEMBER	15.88	N/A
4	D2952-9	FRAME MEMBER	24.25	N/A
4	D2952-11	GUSSET	N/A	N/A
1	D2953-175	SPACER	N/A	N/A
2	D2953-077	SPACER	N/A	N/A
6	D2957	MOUNTING PLATE	N/A	N/A
1	D2983	LABEL PLATE	N/A	N/A
34	MS20600AD4W2	RIVETS	N/A	N/A

NOTES:

- 1) FRAME MATERIAL: 6061-T6, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING (QA-A-200/8 OR QA-A-225/8)
- 2) MESH MATERIAL: 5005-H34 OR 3003-H14 OR 1100-H14/H18 3/4 $\phi 0.051$ F
- 3) GUSSET MATERIAL: 6061-T6 (QQ-A-250/11) OR 5052-H32/H34 (QQ-A-250/8) (3.00 x 3.00) 0.080 THICK
- 4) WELD PER DART QSI 004
- 5) GRIND 0.063 MAX x 45° CHAMFER BEFORE WELDING CORNERS (TYP. 4 PLACES)
- 6) GRIND WELDS FLUSH ON TOP SIDE FOR LABEL PLATE, GRIND CORNER WELDS (4 PLS) BOTTOM SIDE FOR GUSSET
- 7) TRANSFER D2983 LABEL PLATE HOLES USING $\phi 0.128$ DRILL, INSTALL D2983 ONTO FRAME USING MS20600AD4W2 RIVETS (TYP. 34 PLACES)
- 8) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
149913

COPYRIGHT © 2000 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

B	00.07.06	CHANGE FROM SHEET TO MESH; ADD D2952-7/-9/-11
A	00.01.14	NEW ISSUE
DESIGN RF	DRAWN BY RF	DART DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D2952
DATE 00.07.06		TITLE BASKET LID ASSEMBLY
		REV. B SHEET 1 OF 1 SCALE NTS

Date: Monday, 4/23/2007 1:54:11 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 407 BASKET BASE ASSEMBLY
Job Number	: 31999A		
Estimate Number	: 10912		
P.O. Number	: N/A	Part Number	: D2948041
This Issue	: 4/23/2007	Drawing Number	: D2948 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B
Previous Run	: 29857A	Material	: N/A
Written By	:	Due Date	: 5/15/2007
Checked & Approved By	: <u>AD704.23</u>	Qty:	1 Um: Each
Comment	: Est Rev E 04.08.09 Revised Step 1 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
---------	-----------------------	--------------

1.0	M304TS0750W049	304 SQ Tube.75x.75x.049W
-----	----------------	--------------------------



Comment: Qty.: 48.9993 f(s)/Unit Total: 48.9993 f(s)

Material: 304/316 SS tube 0.049" wall

(M304TS0.750W.049)

Batch: m104509 x 19'46"

103240 x 84.5

FC 07/06/14

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



m104509

Comment: LANDING GEAR RESOURCE 1

Cut (2) D2948-5, 3/4" x 3/4" 120" square tubing for bending as per Dwg D2948

3.0	BENDING	BENDING MACHINE
-----	---------	-----------------



Comment: BENDING MACHINE

Form D2948-5 as per Dwg D2948 using CNC bending program 407BASB and Folio FT019

EL 7-6-20

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

07/06/21

5.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2327-3 Spacer

B31785

07/06/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:54:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 BASKET BASE ASSEMBLY

Job Number: 31999A

Part Number: D2948041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 D2581 Mounting Bracket

B31189

11/01/06/21

7.0

D2954

Mounting Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description

Batch

4 D2954 Mounting Plate

B12525

11/02/06/21

8.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 33.6000 sf(s)/Unit Total : 33.6000 sf(s)

Pick:

Qty Part Number Description

Batch

32sf M304EX0.75-16F SS Expanded Metal

M104001

11/07/06/26

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Trim to length as per Dwg D2948 and Deburr/Identify as D2948-5

2-Cut 3/4" x 3/4" square tubing as per Dwg D2948

Identify properly as D2948-1/-3/-7/-9

3-Remove all Markings From Material.

4-Weld as per Dwg D2948 and QSI 004. Deburr as required.

A/R SS Rod

Batch: M102756

11/02/06/26

(PIC)

10.0

QC9

VISUAL WELDING INSPECTION





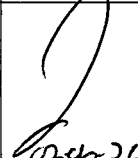




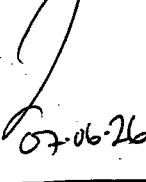




Comment: VISUAL WELDING INSPECTION

PD 07-06-26(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 07-06-26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-06-26	9.0	2x D2948-7 members were placed at 24.5" from the center, instead of 24.250". Root Cause: Human error.	 QSI012	- Remove the 2 D2948-7 members and scrap and replace H10450K - Grind welds off smooth. - locate the D2948-7's AS per DWG ONLY TRACK* <u>Verify distance by Q.C.</u> PD070606	 PD070606	 QSI012	 QSI012	 PD070606
 QSI012	 QSI012		 QSI012	- weld D2948-7 in to location and re-track mesh per DWG, and QSI 004.	 PD070606	 QSI012	 QSI012	 PD070606

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:54:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 BASKET BASE ASSEMBLY

Job Number: 31999A

Part Number: D2948041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07-06-26 C

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M104 744

BR/M-L 07-06-28

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/06/28

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 07/06/28

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-06-28

Job Completion



07-06-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

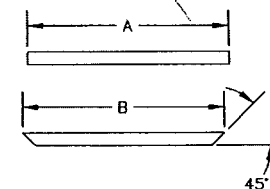
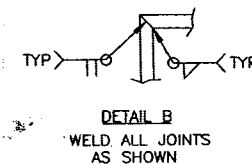
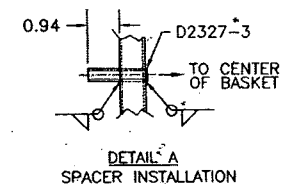
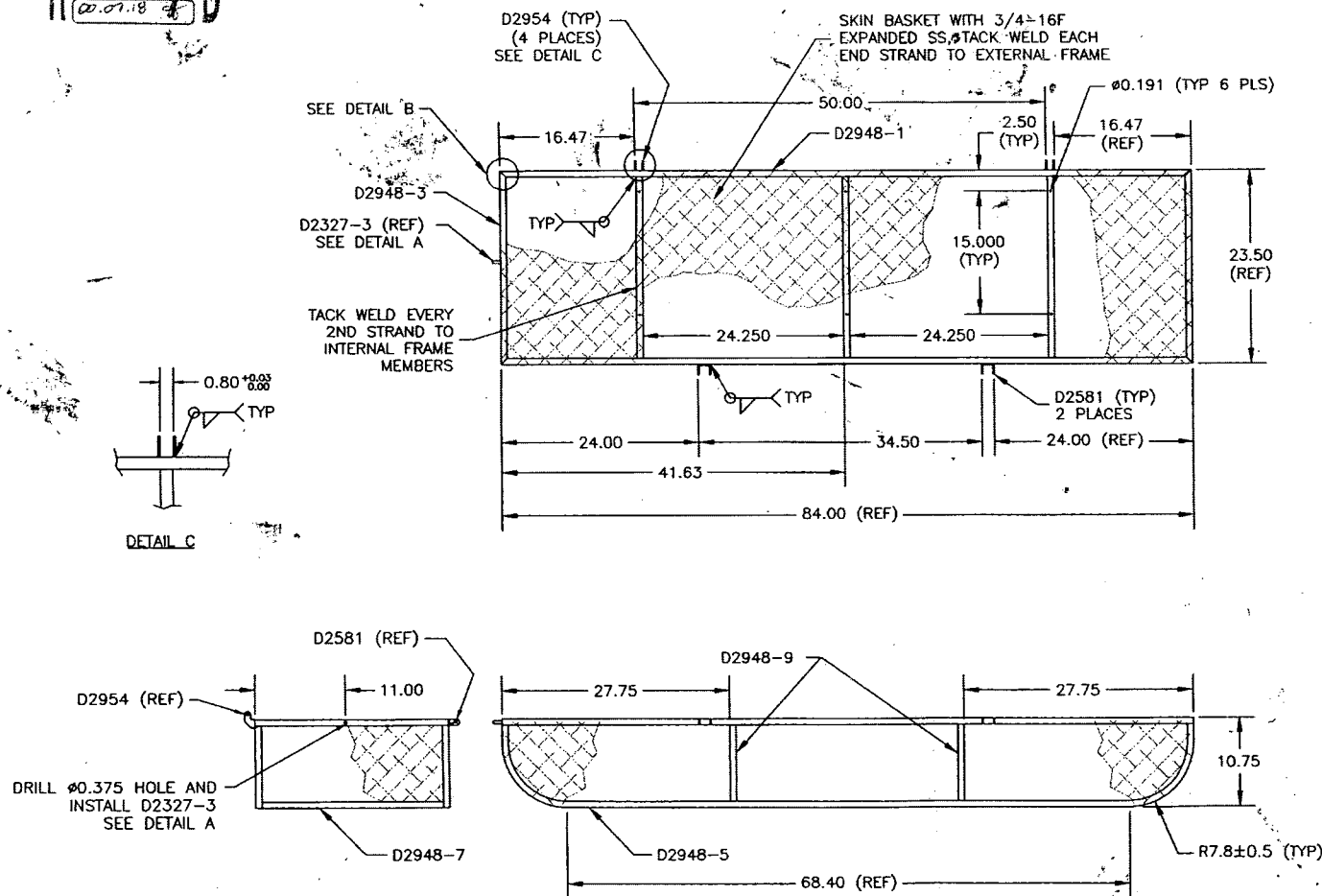
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
00.07.18



QTY	PART	DESCRIPTION	LENGTH	LENGTH
-041	NUMBER		A	B
X	D2948-041	BASKET ASSEMBLY	N/A	N/A
2	D2948-1	FRAME MEMBER	N/A	84.00
2	D2948-3	FRAME MEMBER	N/A	23.50
2	D2948-5	FRAME MEMBER	95.97	N/A
3	D2948-7	FRAME MEMBER	22.00	N/A
4	D2948-9	FRAME MEMBER	9.25	N/A
1	D2327-3	SPACER	N/A	N/A
2	D2581	MTG BRACKET	N/A	N/A
4	D2954	MOUNTING PLATE	N/A	N/A

FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.049 WALL SQUARE TUBING
MESH MATERIAL: 3/4-16F EXPANDED SS
FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
WELD PER DART QSI 004
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31999A

COPYRIGHT © 2000 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

B	00.07.17	ADD Ø0.191; R7.8 WAS R6.8
A	00.01.12	NEW ISSUE
DESIGN	RF	DRAWN BY
CHECKED	RF	APPROVED
DATE	00.07.17	TITLE
		BASKET BASE ASSEMBLY

DART DART AEROSPACE LTD.
HARRISBURG, ONTARIO, CANADA

DRAWING NO. D2948
REV. B
SHEET 1 OF 1
SCALE NTS

